

IN THE CLAIMS:

Please replace the paragraph containing the single word CLAIMS, beginning at Page 8, line 1 with the following rewritten paragraph:

WHAT IS CLAIMED IS:

The following listing of claims will replace all prior versions, and listings, of claims in the application:

1. (Currently Amended) Multi-stand photogravure machine
comprising: with

a first ~~(10)~~ printing unit containing an impression roller and a driven print cylinder, and

at least one additional printing unit, ~~(12a, 12b)~~ each
including: containing

an impression roller in contact with a printable material, ~~(32, 52)~~ and

a driven contacting print cylinder, and ~~(34, 54),~~
~~characterized in that, in the at least one additional printing unit (12a, 12b), the impression roller (52) is provided with~~

a regulated drive ~~(56) and is in contact with the printable material (16), so that it can~~ associated with the impression roller to sustain a web velocity of the printable material ~~(16)~~ varying from ~~the~~ a circumferential speed of the contacting print cylinder ~~(54).~~

2. (Currently Amended) Multi-stand photogravure machine of claim 1, ~~wherein characterized in that~~, in the at least one additional printing unit ~~(12a)~~, the regulated drive ~~(56)~~ of associated with the impression roller ~~(52)~~ ~~contains~~ includes a metering roll ~~(48)~~, which is disposed adjacent to ~~the~~ a course of the web and measures the web tension.

3. (Currently Amended) Multi-stand photogravure machine of claim 1, ~~wherein or 2, characterized in that~~ each driven impression roller ~~(52)~~ has a drive, in which an acceleration or deceleration can be set with respect to another impression roller ~~(32)~~.

4. (Currently Amended) Multi-stand photogravure machine of claim 1, ~~wherein one of the preceding claims, characterized in that~~ the print cylinder ~~(54)~~ of the at least one additional printing unit ~~(12a, 12b)~~ ~~has~~ includes a drive, in which an acceleration or deceleration with respect to the print cylinder ~~(34)~~ of the first printing unit ~~(10)~~ can be set.

5. (Currently Amended) Photogravure process for a multi-stand photogravure machine including with a first ~~(10)~~ printing unit containing an impression roller and a driven print cylinder, and at least one additional printing unit ~~(12a, 12b)~~, each

additional printing unit including ~~containing~~ an impression roller ~~(32, 52)~~ and a driven print cylinder, ~~(34, 54)~~, characterized in that the process comprising the steps of:

actively driving the impression roller ~~(52)~~ of the at least one additional printing unit ~~(12a, 12b)~~ ~~is actively driven~~ and ~~that, by means of the~~

regulating the web tension of a web by a drive of the impression roller ~~(52)~~ of the at least one additional printing unit ~~(12a, 12b)~~, ~~the web tension of a web (16) is regulated.~~

6. (Currently Amended) Photogravure process of claim 5, further comprising the steps of: ~~characterized in that,~~

setting the web velocity, upon the start-up of the photogravure machine, when the print cylinders ~~(34, 54)~~ are brought to a uniform, regulated rotational speed, ~~the web velocity is set~~ by a draw-in mechanism, ~~(14)~~ and

regulating the rotational speed of each driven impression roller ~~(32, 52)~~ ~~is so regulated~~ such that a uniform web tension results in all printing units ~~(10, 12a, 12b)~~.

7. (Currently Amended) Photogravure process of claim 5 or 6, further comprising the steps of: ~~characterized in that,~~

setting the web velocity, upon start-up, of the impression roller ~~(32)~~ of the printing unit ~~(10)~~ adjacent to ~~one~~ a draw-in mechanism ~~(14)~~ ~~sets the web velocity,~~ and

regulating the rotational speed of a draw-in mechanism ~~(14)~~ and impression roller ~~(52)~~ of the at least one additional printing unit ~~(12a, 12b)~~ ~~are regulated~~, so that a uniform web tension results.

8. (Currently Amended) Photogravure process of claim one ~~of the claims 5 to 7, further comprising the step of:~~
~~characterized in that,~~

regulating, during start-up, the rotational speed of the print cylinder ~~(54)~~ in the at least one additional printing unit ~~(12a, 12b)~~ ~~is regulated by means of~~ an optical sensor ~~(58)~~ so that register accuracy is achieved.

9. (Currently Amended) Photogravure process of claim one ~~of the claims 5 to 8, further comprising the steps of:~~
~~characterized in that,~~

sustaining, during ~~the~~ a run time, the rotational speeds of the impression rollers ~~(32, 52)~~ attained in the start-up ~~are sustained,~~ and

making a reaction ~~is made~~ to departures from ~~the~~ a uniform web tension with brief variations of a set speed of a driven impression roller ~~(52)~~ from the rotational speed reached during start-up.

10. (Currently Amended) Photogravure process of claim one ~~of the claims 5 to 9, further comprising the steps of:~~
~~characterized in that,~~

sustaining, during a run time, the speeds of the print cylinders ~~(34, 54)~~ reached during start-up ~~are sustained~~, and
making a reaction ~~is made~~ to register errors with brief departures of a set speed from the speed reached during start-up.

11. (Currently Amended) Photogravure process of claim 9,
~~characterized in that,~~ wherein the step of making a reaction to
departures to produce the brief ~~departure~~ variations of the set speed of a driven impression roller ~~(52)~~, includes the step of
establishing an acceleration or deceleration with respect to another impression roller ~~(32)~~ ~~is established~~ at the drive of the other impression roller ~~(52)~~.

12. (Currently Amended) Photogravure method of claim 10,
~~characterized in that,~~ wherein the step of making a reaction to produce the brief departure of the set speed of a print cylinder ~~(54)~~, includes the step of establishing an acceleration or deceleration, with respect to another print cylinder ~~(34)~~, ~~is established~~ at the drive of the other print cylinder ~~(54)~~.